

Date: Thursday, 07/05/2009 8:27:19 AM
 User: Melanie Fauteux

Process Sheet

Customer	: CC-DAR01 Dart Aerospace Ltd.	Drawing Name	: D206-642-511
Job Number	: 47767		
Estimate Number	: 10804		
P.O. Number	:	Part Number	: D206642511
This Issue	: 07/05/2009 S.O. No. :	Drawing Number	: R09-044
Prsht Rev.	: NC	Project Number	:
First Issue	: // Type : SKIDTUBES	Drawing Revision	:
Previous Run	: 00015	Material	:
Written By	: <u>200507</u>	Due Date	: 13/05/2009 Qty: 1 Um: Each
Checked & Approved By	: <u>MF 09-05-07</u>		
Comment	:		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D206642511	Float Skidtube LH
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 Float Skidtube LH
 Original B33848 @ CHG003

2.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP
 Tube is good. no stripped bolts, or inserts. All are correctly torqued etc.
 LPS 3 was apparent on the outside of the tube, and some minor scratches.

3.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1
 -Dis-assemble the entire tube.
 -Keep and identify all the hardware for re-assembly.
 -Remove the aft cap and remove/wash all LPS 3 out of the interior of the tube.

When the tube is clean and degreased per QSI005 with wash'n'wipe, sand the entire surface, and the scratches on the powder coat are sanded out, re-powder coat white in accordance with QSI005.

*** Strip the tube if necessary***

Powdercoat the wear pads as necessary

4.0	POWDER COATING	POWDER COATING
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Comment: POWDER COATING

Powder coat white per QSI005

M 111472

BR 09-05-13

D.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 07/05/2009 8:27:19 AM
User: Melanie Fauteux

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D206-642-511

Job Number: 47767

Part Number: D206642511

Job Number:



Seq. #:

Machine Or Operation:

Description :

Start time: 3:20
Oven temp: 320°
Finish time: 3:50

BR 09-05-13 ①

Powder coat the wearpads grey as necessary per QSI005

Qty _____

Start time: _____

Oven temp: _____

Finish time: _____

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-05-14

②

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

-Re-assemble the tube using the original hardware.

If necessary pick and record the hardware needed for re-assembly:

P/N	Batch	Qty
D3536-15	B47315	1
D3536-23	B46884	1
D3536-35	B46885	1
D3536-39	B44648	1
AN 960C14	B111548	NA
AN 960C10L	B111668	50
D3622-1	B42329	2
AN 96C-4A	B111668	80

BR 09-05-14 ①

*** Ensure Melanie does an adjustment in Accpac***

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Original k642-511 saddle kit B33664 is quarantined at the inspection area for re-packaging.

09/05/14

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 07/05/2009 8:27:19 AM
User: Melanie Fauteux

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D206-642-511

Job Number: 47767

Part Number: D206642511

Job Number:



Seq. #:

Machine Or Operation:

Description :

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

New label, decal, and paperwork are required with the new batch # @ CHG003

Re-package

Original k642-511 saddle kit B33664 is quarantined at the inspection area for re-packaging

9.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

Ensure original kit is placed back with the correct tube

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Return to stock

Location: _____

Job Completion



47767

MF
09-05-28

11.0 QC 21 09/05/28

DART		TEL: 1-613-632-3336 FAX: 1-613-632-4443	
TRANSPORT CANADA APPROVAL # 09-89			
P.N.	D206-642-511	CHG	CHG003
DES	Float Skidtube LH	STC	SH98-4
LOT	B33848	STC	SA00475SE
REV	206L/L1/L3/L4/407	STC	
US PATENT # 6,735,444 CANADA FOREIGN PATENTS PENDING		MADE IN CANADA	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 8/8/2007 12:56:12 PM
 User: Jean-Luc Menard

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : FLOAT SKID LH 206L1,L3,L4&407
 Job Number : 33848
 Estimate Number : 10307
 P.D. Number : *N/A* Part Number : D206642511
 This Issue : 8/8/2007 S.O. No. : *N/A* Drawing Number : N/A
 Prsht Rev. : NC Project Number : N/A
 First Issue : *N/A* Type : LANDING GEAR Drawing Revision : K
 Previous Run : 33847 Material : *N/A*
 Due Date : 8/15/2007 Qty: 1 Um: Each
 Written By : *JLM 07-08-08*
 Checked & Approved By :
 Comment : Est Rev: B 05.09.23 Revised per D206-642 Rev. J KJJ/JLM
 Est Rev: C 07-02-23 As per IIN D206-642 Rev K JLM
 est rev D 07.06.06 added K642-511 EC

Additional Product

REFERENCE ONLY

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



KJ 07-08-27

Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D206-642-511CHG003

En 07/09/12

2.0 33848A FLOAT SKIDTUBE ASSEMBLY



Comment: Sub-Component FLOAT SKIDTUBE ASSEMBLY

D206-642-541 B *33848A**En 7/9/12 ①*

3.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

4.0 K642 511 saddle kit 642-511



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

saddle kit 642-511

Batch: *B 33664**En 07/9/12 ①*

5.0 QC4 INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

En 07/09/12

Date: Thursday, 7/19/2007 2:26:48 PM
 User: Jim Johnston

Process Sheet

SPLIT

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SADDLE KIT FOR D206-642-511
 Job Number : 33664 -
 Estimate Number : 12893
 P.O. Number : N/A Part Number : K642 511
 This Issue : 7/19/2007 S.O. No. : N/A Drawing Number : N/A
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : LANDING GEAR Drawing Revision : N/A
 Previous Run : 33484 Material : N/A Due Date : 8/3/2007 Qty: 3 Um: Each
 Written By :
 Checked & Approved By :
 Comment : Est Rev: A 07.06.05 new issue EC

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP K642-511 CHG003

2.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

3.0

D206648013

GHW Kit



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

GHW Kit

Batch: B33666 (2x) - 33231 - 7/18/08

4.0

D2652

Bushing



Comment: Qty.: 16.0000 Each(s)/Unit Total: 64.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

16 D2652

Bushing

B32621 (28x) - B32987 (36x) -

5.0

D2712

Set Screw



Comment: Qty.: 10.0000 Each(s)/Unit Total: 40.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

10 D2712

Set Screw

B32506 -

7/18/08

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Kim Johnston


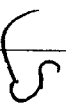

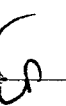

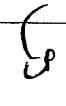



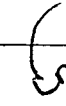

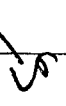
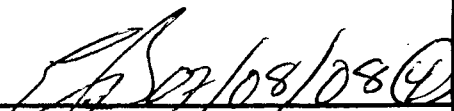
Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE KIT FOR D206-642-511

Job Number: 33664

Part Number: K642 511

Seq. #:	Machine Or Operation:	Description :
6.0	D29321	206 Saddle Left side
		
		
Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)		
Pick:		
Qty Part Number Description Batch		
1 D2932-1 Saddle B32021 (3x) - B33654 (2x)		
7.0	D29331	206 Saddle Left
		
		
Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)		
Pick:		
Qty Part Number Description Batch		
1 D2933-1 Saddle B33353 (3x) - B32379 (2x)		
8.0	D2934	Saddle Spacer
		
		
Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)		
Pick:		
Qty Part Number Description Batch		
2 D2934 Saddle Spacer B52628		
9.0	D2935	Saddle Spacer
		
		
Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)		
Pick:		
Qty Part Number Description Batch		
2 D2935 Saddle Spacer B33219		
10.0	D29381	206 Saddle Left side
		
		
Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)		
Pick:		
Qty Part Number Description Batch		
1 D2938-1 Saddle B33355		
11.0	D29391	206 Saddle Left side
		
		
Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)		
Pick:		
Qty Part Number Description Batch		
1 D2939-1 Saddle 34145		
		

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Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE KIT FOR D206-642-511

Job Number: 33664

Part Number: K642 511

Job Number



Seq. #:

Machine Or Operation:

Description :

12.0

D33963

Inventory



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)
Pick:

Qty Part Number Description Batch
2 D3396-3 Spacer B32784 ✓

13.0

D3407043

Tow Ring



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
Pick:

Qty Part Number Description Batch
1 D3407-043 Tow Ring B33375 (N) - B32893 (34) -

14.0

D34561

washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
Pick:

Qty Part Number Description Batch
1 D3456-1 ✓ Washer B33276 -

15.0

D34571

Inventory



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)
Pick:

Qty Part Number Description Batch
2 D3457-1 Washer B32409 ✓

16.0

AN3C35A



Comment: Qty.: 3.0000 Each(s)/Unit Total : 12.0000 Each(s)
Pick:

Qty Part Number Description Batch
3 AN3C35A Bolt M104955 ✓

17.0

AN3C36A



Comment: Qty.: 9.0000 Each(s)/Unit Total : 36.0000 Each(s)
Pick:

Qty Part Number Description Batch
9 AN3C36A Bolt M101261 ✓

207/08/08 (9)

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE KIT FOR D206-642-511

Job Number: 33664

Part Number: K642 511

Job Number



Seq. #:

Machine Or Operation:

Description :

18.0

AN3C41A



Comment: Qty.: 8.0000 Each(s)/Unit Total: 32.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

8 AN3C41A

Bolt

M105118

(25x)

M105160

(7x)

19.0

AN4C6A



Comment: Qty.: 12.0000 Each(s)/Unit Total: 48.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

12 AN4C6A

Bolt

M104936

20.0

AN5C11A



Comment: Qty.: 8.0000 Each(s)/Unit Total: 32.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

8 AN5C11A

Bolt

M105143

21.0

AN5C12A



Comment: Qty.: 4.0000 Each(s)/Unit Total: 16.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

4 AN5C12A

Bolt

M104936

22.0

AN5C13A



Comment: Qty.: 4.0000 Each(s)/Unit Total: 16.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

4 AN5C13A

Bolt

M104936

23.0

AN5C15A



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 AN5C15A

Bolt

M101291

CP 08/08/08

Process Sheet

Cus omer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE KIT FOR D206-642-511

Job Number: 33664

Part Number: K642 511

Job Number:



Seq. #:

Machine Or Operation:

Description:

24.0

AN5C32A



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 AN5C32A

Bolt

M105156 ✓

25.0

AN5C34A



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 AN5C34A

Bolt

M18918 ✓

26.0

AN5C35A



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 AN5C35A

Bolt

M18918 ✓

27.0

AN960C10L

washer



Comment: Qty.: 24.0000 Each(s)/Unit Total: 96.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

24 AN960C10L

Washer

M104537 ✓

28.0

AN960C416L

WASHER



Comment: Qty.: 24.0000 Each(s)/Unit Total: 96.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

24 AN960C416L

Washer

M104916 (19)

M104936 (77)

EP 07/28/08 @

Thursday, 7/19/2007 2:26:48 PM

Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE KIT FOR D206-642-511

Job Number: 33664

Part Number: K642 511

Job Number:



Seq. #:

Machine Or Operation:

Description:

29.0

AN960C516L

WASHER



Comment: Qty.: 8.0000 Each(s)/Unit Total: 32.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

8 AN960C516L

Washer

M103344 ✓

30.0

MS210433

Nut



Comment: Qty.: 20.0000 Each(s)/Unit Total: 80.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

+1 20 MS21043-3

Nut

M104995 ✓

31.0

MS210434

Nut



Comment: Qty.: 13.0000 Each(s)/Unit Total: 52.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

13 MS21043-4

Nut

M104936 ✓

32.0

MS210435

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total: 16.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

4 MS21043-5 Nut

M104729 ✓

33.0

NAS1515H3L

WASHER



Comment: Qty.: 24.0000 Each(s)/Unit Total: 96.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

24 NAS1515H3L

Washer

M104291 ✓

34.0

NAS1515H4L

Inventory



Comment: Qty.: 24.0000 Each(s)/Unit Total: 96.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

21 1 1 1

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE KIT FOR D206-642-511

Job Number: 33664

Part Number: K642 511

Job Number:



Seq. #:

Machine Or Operation:

Description:

24 NAS1515H4L Washer M105136 -

35.0

NAS1515H5

Washer



Comment: Qty.: 16.0000 Each(s)/Unit Total: 64.0000 Each(s)

Pick:

Qty Part Number

Description:

Batch

16 NAS1515H5

Washer

M105135 -

36.0

NAS1515H5L

WASHER



Comment: Qty.: 8.0000 Each(s)/Unit Total: 32.0000 Each(s)

Pick:

Qty Part Number

Description:

Batch

8 NAS1515H5L

Washer

M104956 -

37.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

38.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP K642-511 CHG003

Location:

39.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U OF 9.12